

# Work Order ID 55210

January 12, 2010 10:37:51 AM

ASAP



Page 1

Item ID: D3570-2

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 1/12/10 Start Qty: 30.00



Cust Item ID:

Required Date: 1/18/10 Req'd Qty: 30.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3570

Rev E

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3570

Dwg Rev: E

Prog Rev: E

\*\*\*GRAIN DIRECTION AS PER DWG\*\*\*

2-Deburr if necessary

HB 10-1-12

31

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

HB 10-1-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 55210

January 12, 2010 10:37:51 AM

Page 2

Item ID: D3570-2

Accept

Revision ID:

Item Name: Bracket

Start Date: 1/12/10

Start Qty: 30.00

Required Date: 1/18/10

Req'd Qty: 30.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

27 8/10/13

counter  
31

130

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Form as per Dwg D3570 Using DT8945

2-Cut excess materials per Dwg D3570.

3-Drill as per Dwg D3570 Using Dt8946

7 m-h 10/01/13

31X

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

27 8/10/14

counter  
31  
-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 55210

January 12, 2010 10:37:52 AM

Page 3

Item ID: D3570-2

Accept

Setup Start

Revision ID:

Stop

Item Name: Bracket

Start Date: 1/12/10 Start Qty: 30.00

Cust Item ID:

Required Date: 1/18/10 Req'd Qty: 30.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

MI

10-01-14

31

Ø

HandFinish

Memo

0.00

Hand Finishing

160

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

M112588

=> MI

10/01/14

X30

Ø

Powdercoat

Memo

0.00

Powder Coating

START TIME: 2:15pm  
OVEN TEMPERATURE: 320°F  
FINISH TIME: 2:45pm

170

QC3- Inspect Part Finish

0.00

PK

10-01-14.

30

Ø

QC

Memo

0.00

Quality Control

# Work Order ID 55210

January 12, 2010 10:37:52 AM



Page 4

Item ID: D3570-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 1/12/10 Start Qty: 30.00



Cust Item ID:

Required Date: 1/18/10 Req'd Qty: 30.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

Identify as per dwg & Stock Location 245A

0.00



Packaging

Memo

0.00

Packaging

16-1-15 3/2 SP

190

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

10/01/18  
MF 100 01-15

# Picklist Print

January 12, 2010 10:37:49 AM

Page 1

Work Order ID: 55210



Parent Item: D3570-2



Parent Item Name: Bracket

Start Date: 1/12/10

Required Date: 1/18/10

Comments: IPP Rev:A New Issue 07-03.26 ec

Start Qty: 30.00

Required Qty: 30.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	232.1823	2.2105			



6061-T6 .125 Sheet

B 10-1-12

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

232.1823

110062

1.85

111642

19.592

112476

32

112567

18.7403

113424

64

113608

96

113424

31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

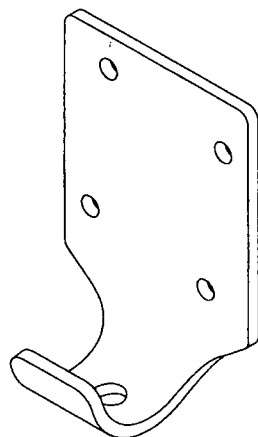
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

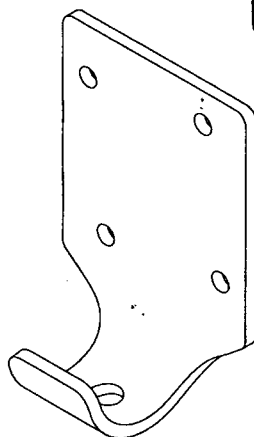
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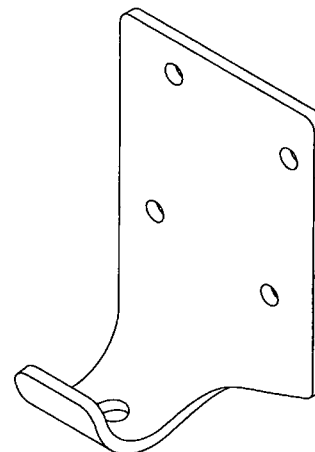




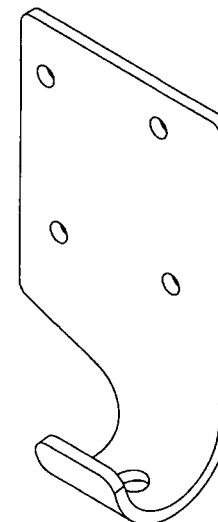
**D3570-1 BRACKET**



**D3570-2 BRACKET**



**D3570-3 BRACKET**



**D3570-4 BRACKET**

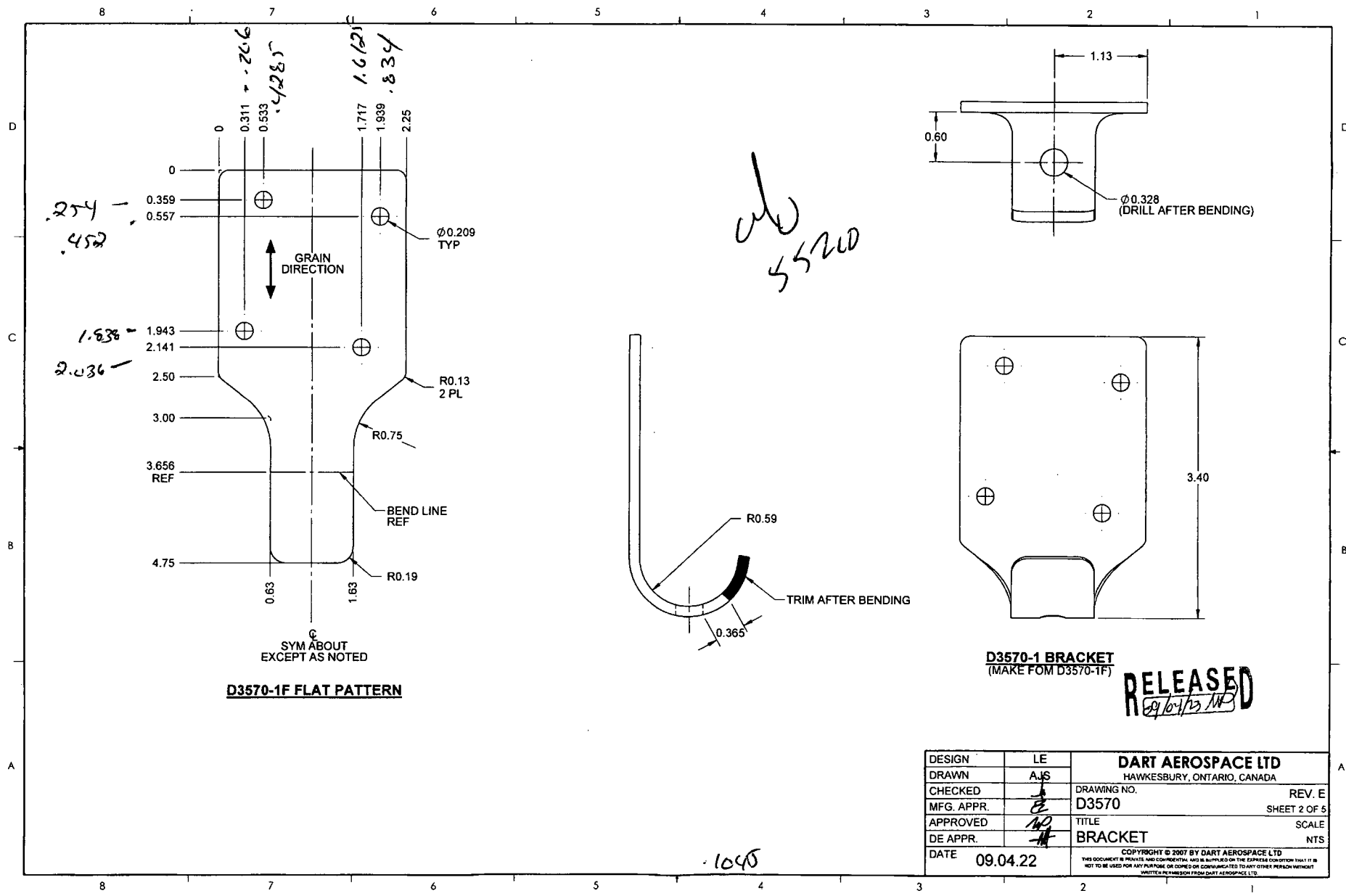
*NO 55210*

**RELEASED**  
*09/04/22*

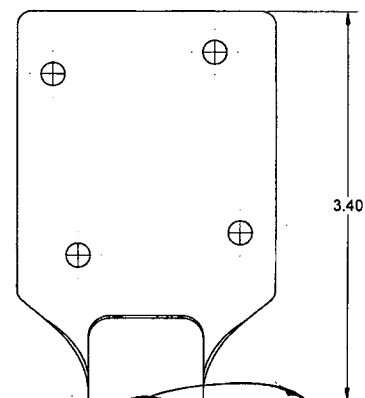
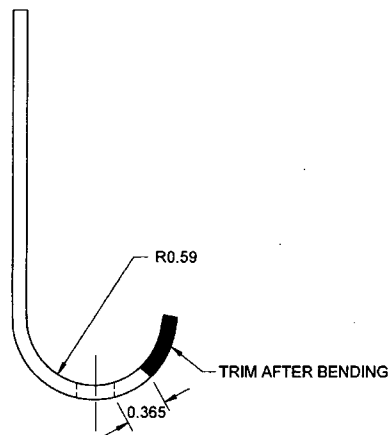
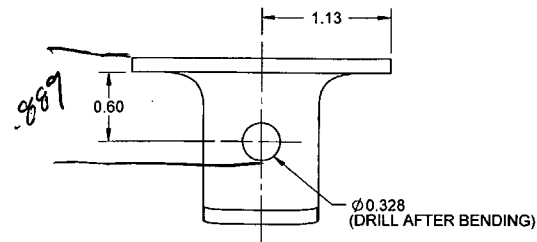
**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027  
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3570-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.10 lbs EACH

E	SHEET 3 UPDATED D3570-3F FLAT PATTERN, SEE REV D FOR DETAILS. SEE PAR 09-014.	AJS	09.04.22
D	ADDED -3 & -4 FOR USE ON 214B/B1. SEE PAR 09-014.	AJS	09.04.01
C	UPDATE DIMS FOR CLARITY	LE	07.06.01
B	CHANGE BEND RAD TO 0.60 FROM 0.50	LE	07.04.16
A	NEW ISSUE	LE	07.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	<b>D3570</b>	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>BRACKET</b>	NTS
DATE	09.04.22	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



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DRAWN	AJS		
CHECKED	J	DRAWING NO.	REV. E
MFG. APPR.	E	D3570	SHEET 2 OF 5
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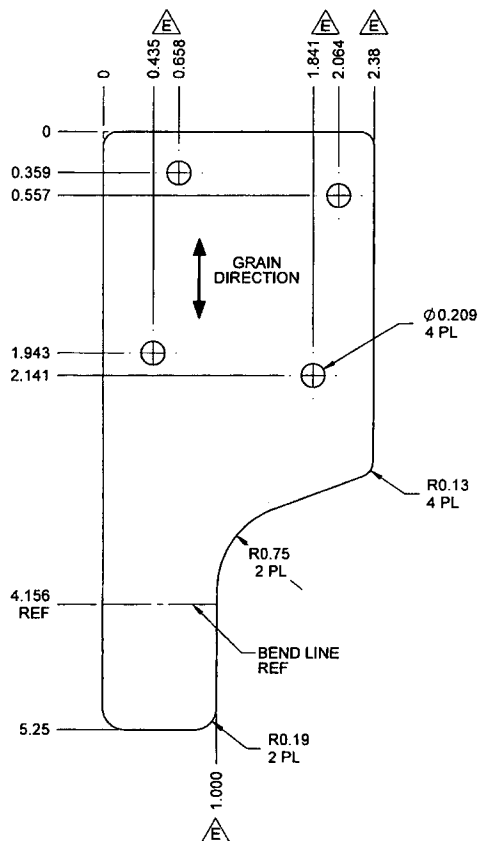
**D3570-2 BRACKET**  
(MAKE FROM D3570-1F)

WLB  
55210

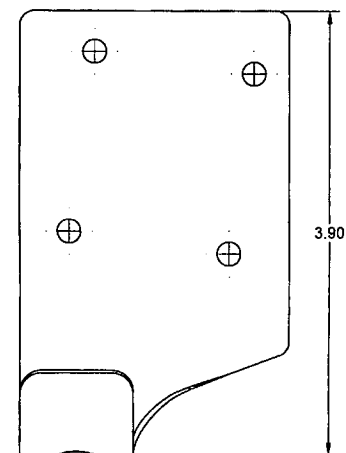
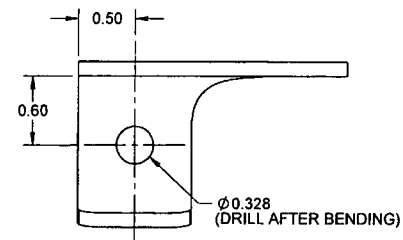
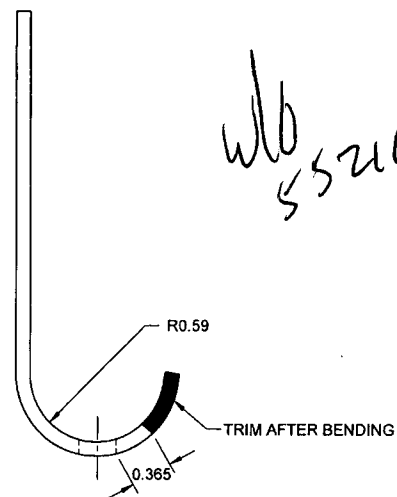
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09/04/22

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MFG. APPR.	E	D3570	SHEET 3 OF 5
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686



**D3570-3F FLAT PATTERN**



**D3570-3 BRACKET**  
(MAKE FROM D3570-3F)

**RELEASED**  
07/24/15

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DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3570	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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